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Abba et al.

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(54) **METHOD AND APPARATUS FOR AXIAL
FEED OF RIBBON MATERIAL**

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(75) **Inventors: Rodney L. Abba, Oshkosh, WI (US);
Robert J. Waldron, Appleton, WI
(US); Robert J. Makolin, Neenah, WI
(US)**

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Correspondence Address:

**SENNIGER POWERS LEAVITT AND
ROEDEL
ONE METROPOLITAN SQUARE
16TH FLOOR
ST LOUIS, MO 63102 (US)**

(57) **ABSTRACT**

A method of controlling twisting in ribbon material fed from a coil of ribbon material into a processing machine. The coil has a central axis perpendicular to a plane of the coil. The method includes pulling ribbon material from the coil in a direction having a twist-promoting axial component relative to the plane of the coil and continuously rotating the coil during the pulling step at a rotational speed greater than zero so that a number of twists in the unwound ribbon is maintained below a predetermined number.

(73) **Assignee: Kimberly-Clark Worldwide, Inc.**

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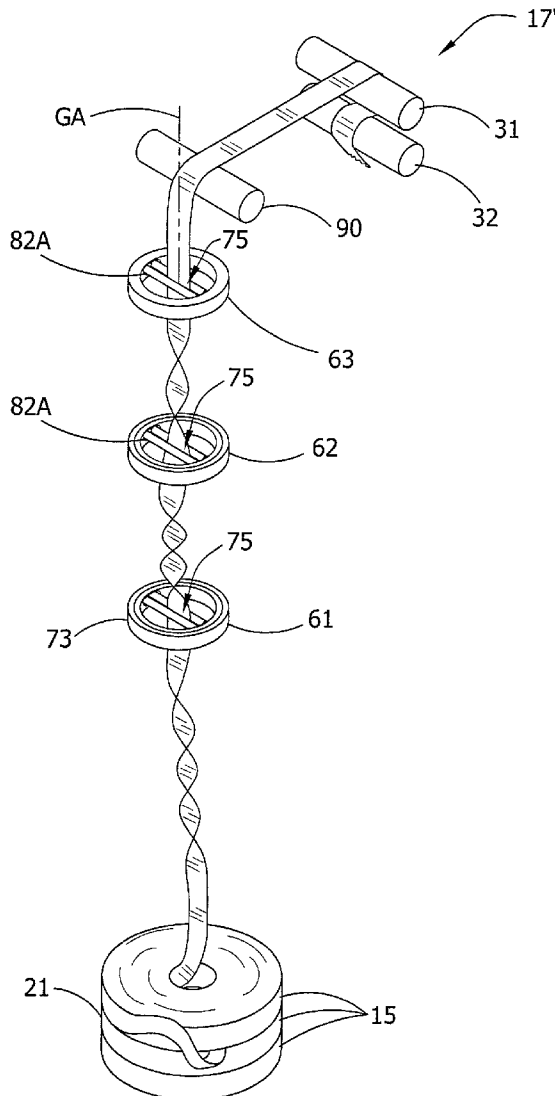


FIG. 1

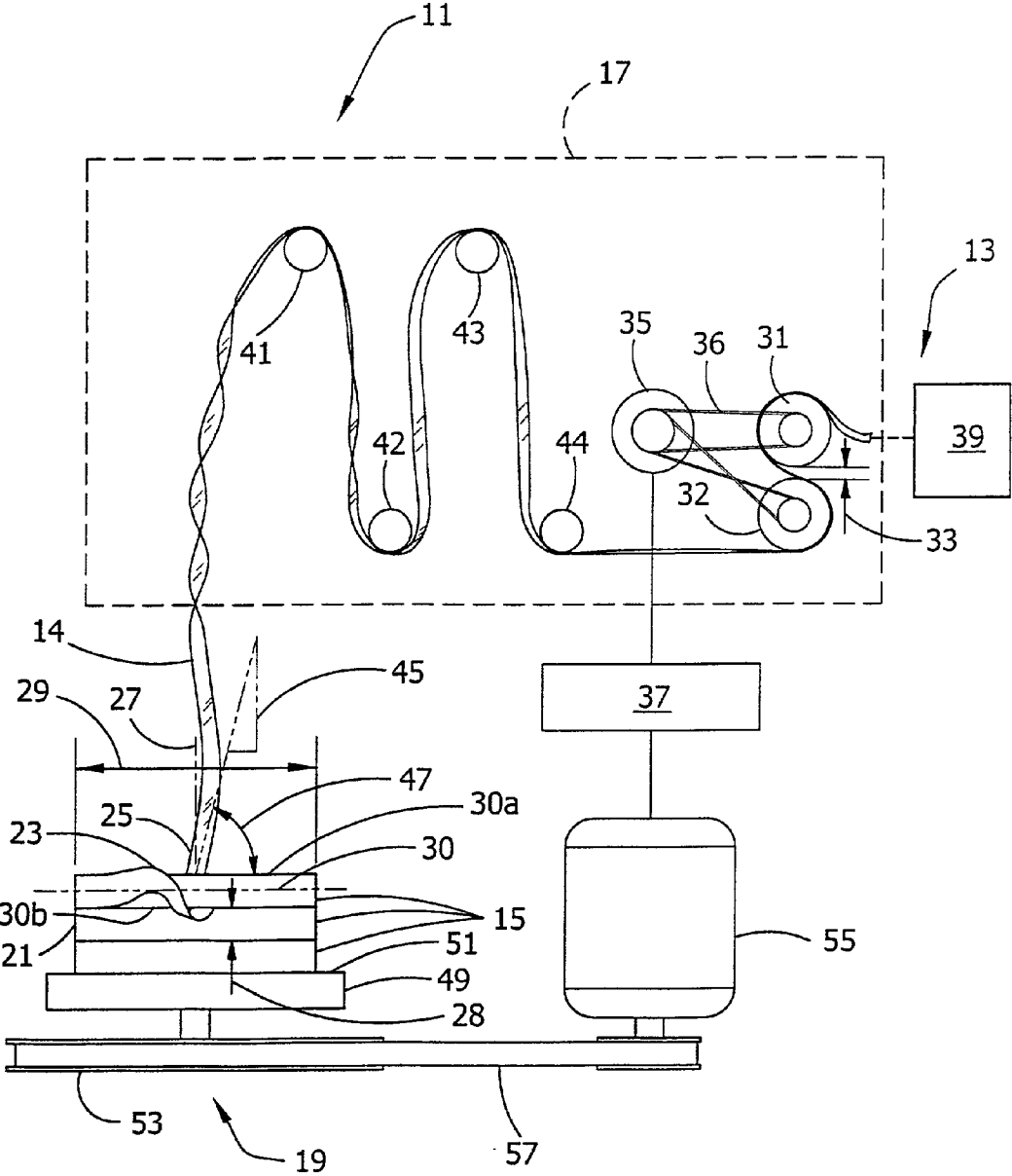


FIG. 2

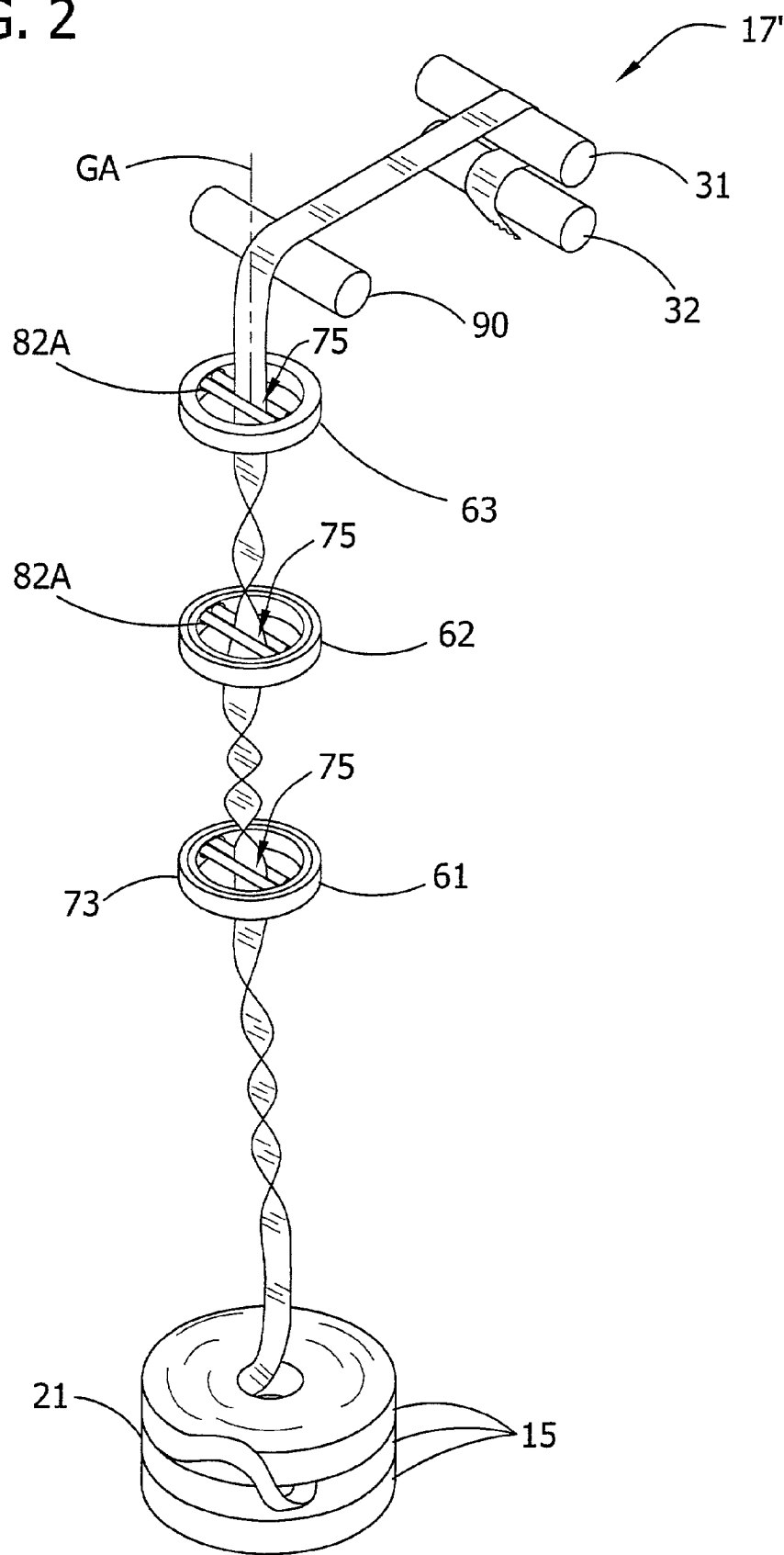


FIG. 3

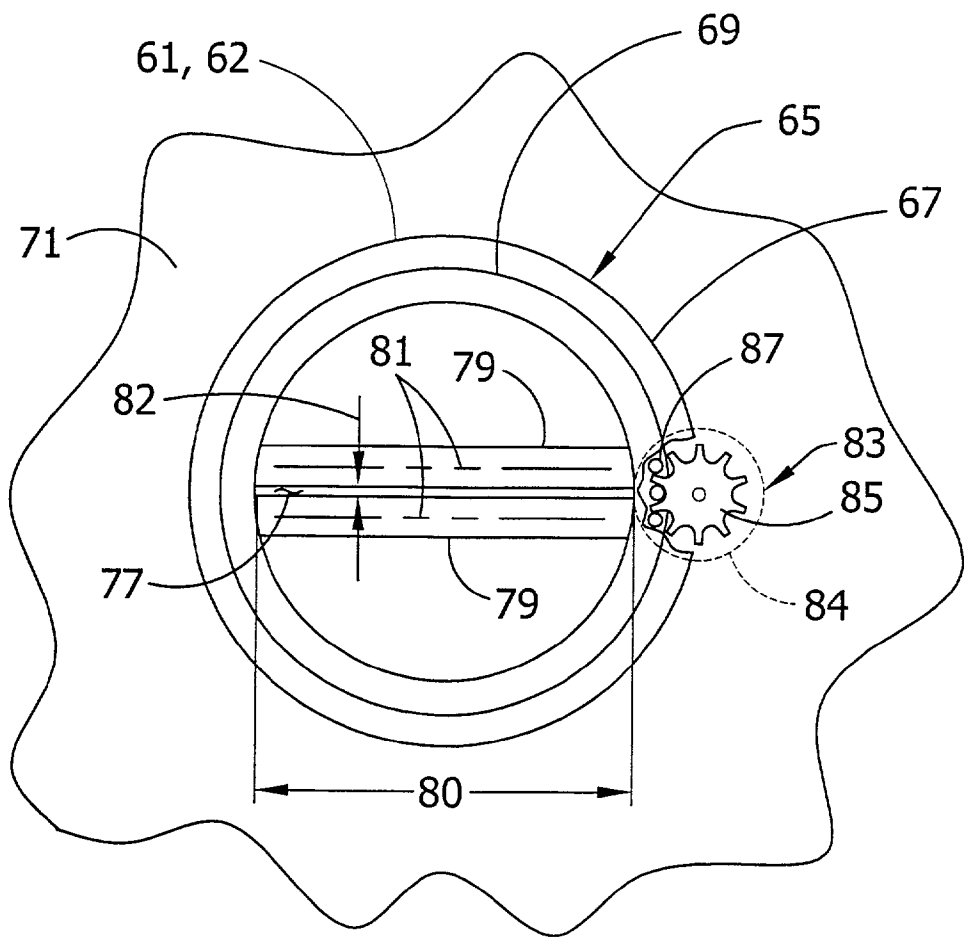
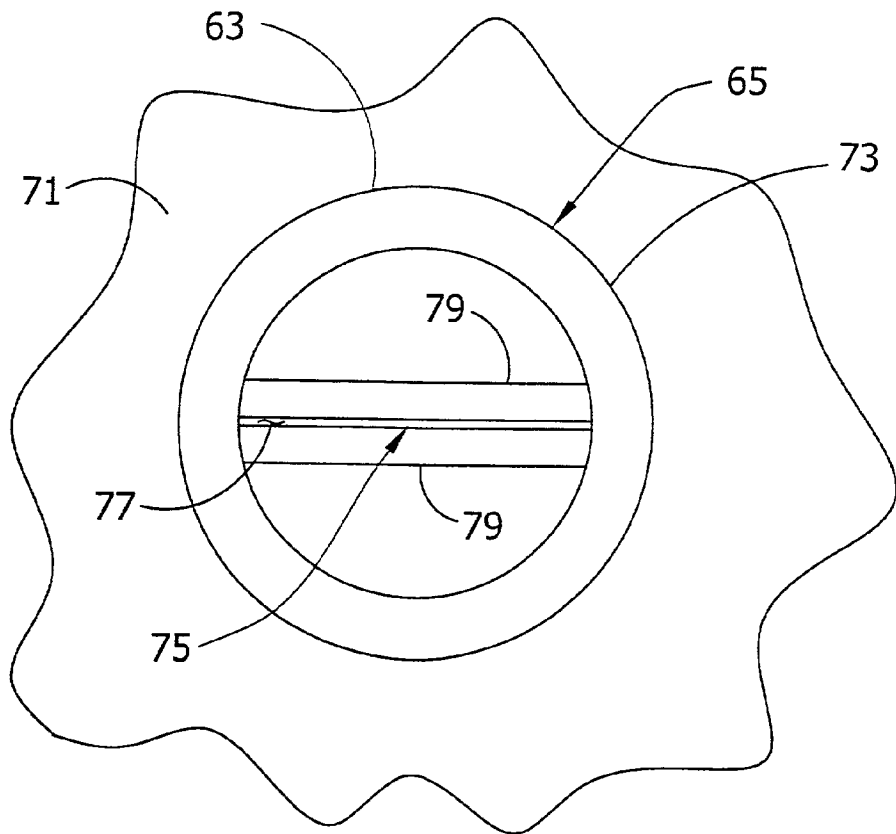


FIG. 4



METHOD AND APPARATUS FOR AXIAL FEED OF RIBBON MATERIAL

BACKGROUND OF THE INVENTION

[0001] The present invention relates generally to continuously supplying flexible raw material generally in the form of a web to a processing machine, and more particularly to a stock of ribbon material and methods for controlling twisting of the ribbon material fed to the processing machine.

[0002] Conventional processing machines, such as those used to convert narrow ribbons of raw material into finished product, run most efficiently when a continuous feed of raw material is provided. If continuous feed of raw material is not maintained, the machine must be shut down to re-thread the ribbon material. Shutting down the machine negatively impacts the efficiency of the machine, especially machines used in high volume processes such as the production of feminine care products.

[0003] Raw absorbent material used to produce feminine care products is initially manufactured as a web of absorbent material measuring one meter or more in width. The processing machine cannot process such a wide web, so the material is trimmed to form many ribbons of a more usable narrow width. The wide web is suitably scored or sheared to form the ribbons. Typically, the ribbons are then wound onto cores to form coils or "pancake slits", so-called due to the fact they resemble pancakes when laid flat. Each coil has a thickness substantially equal to a width of the ribbon material, and each successive revolution or turn of ribbon substantially overlies the preceding revolution so that the coil is no thicker than the ribbon material is wide.

[0004] The coils are shipped to a factory where the processing machine is located, and one coil at a time is mounted on a horizontal axis spindle for continuous feed of raw material into the processing machine. The machine pulls the ribbon in a direction tangential to the coil, i.e., parallel to a plane of the coil and perpendicular to an axis of the coil, so that there is no twisting of the ribbon during feeding. The spindle is a variable-speed motorized spindle with sufficient capacity for mounting only one coil of absorbent material. The spindle is variable-speed to keep tension in the ribbon as it is fed into the machine. It will be understood that at a constant linear feed rate, the coil will rotate faster as its supply of ribbon is consumed by the machine. Due to the high cost of each spindle, no more than two spindles are typically provided at the machine. Thus, as a first coil is consumed, a second coil is mounted on the second spindle, and the trailing end of the first coil is spliced to a leading end of the second coil.

[0005] An obvious disadvantage of this arrangement is that an operator must be standing by to load coils as they are consumed by the machine. The time period between changing coils (referred to as runout time) will vary with the length of the material on the coil and the speed of use by the processing machine. In the case of a relatively high throughput feminine pad machine, a typical one thousand lineal meter coil of absorbent material will be consumed in three to nine minutes. Due to this relatively short runout time, the processing machine requires constant manpower to maintain continuous feed. Moreover, the short runout time and the difficulty of loading the bulky coil on the spindle increases

the likelihood that the splice will fail (e.g., due to operator error or mechanical problems in splicing) and the likelihood that the machine will have to be shutdown for re-threading.

[0006] There are other methods of providing continuous feed material to a processing machine. For example a processing machine is shown in U.S. Pat. No. 1,178,566 (Wright) wherein the ribbon material is formed into a stack of coils, and an end of the upper coil is pulled parallel to the axis of the coil into the machine. This arrangement causes the ribbon material to twist as it is unwound. The patent shows a device for removing the twists including a rotatable guide which rotates in response to twists in the ribbon and a powered turntable which intermittently rotates the coils (i.e., rotation starts and stops repeatedly) in response to rotation of the guide.

SUMMARY OF THE INVENTION

[0007] In one aspect, the present invention provides a method of controlling twisting in ribbon material fed from a coil of ribbon material into a processing machine. The coil has a central axis perpendicular to a plane of the coil. The method includes pulling ribbon material from the coil in a twist-promoting direction and continuously rotating the coil during the pulling step at a rotational speed selected so that a number of twists in the unwound ribbon is maintained below a predetermined number.

[0008] In another aspect, the present invention provides a method of controlling twisting in ribbon material fed from a coil of ribbon material into a processing machine. The coil has a central axis perpendicular to a plane of the coil. The method includes pulling ribbon material from the coil in a twist-promoting direction and continuously rotating the coil during the pulling step at a rotational speed selected such that the number of twists in the unwound ribbon is maintained sufficiently low so that the material is substantially untwisted at a downstream portion of an intake feed mechanism of the processing machine.

[0009] In yet another aspect, the present invention provides a feed system of a processing machine for continuously feeding a coil of ribbon material thereto. The system includes an intake feed mechanism for pulling the ribbon material into the processing machine. The intake feed mechanism is adapted to pull the ribbon material from the coil in a twist-promoting direction. A powered turntable is positioned upstream from the intake feed mechanism for supporting the coil. The turntable continuously turns while the intake feed mechanism pulls the ribbon material into the processing machine.

[0010] In still another aspect, the present invention provides a feed system of a processing machine for continuously feeding ribbon material thereto. The system includes a turntable and a coil of the ribbon material mounted on the turntable. The coil has a central axis perpendicular to a plane of the coil. The system further includes means for pulling the ribbon material from the coil into the processing machine. The pulling means are adapted to pull the ribbon material from the coil in a twist-promoting direction. The system also includes means for continuously rotating the turntable and coil so as to reduce twisting in unwound ribbon material.

[0011] Other features of the present invention will be in part apparent and in part pointed out hereinafter.

BRIEF DESCRIPTION OF THE DRAWINGS

[0012] FIG. 1 is a schematic front elevation of an axial feed system of the present invention,

[0013] FIG. 2 is a schematic perspective of an axial feed system of a second embodiment of the present invention,

[0014] FIG. 3 is a schematic top plan of a gate device of the second embodiment adapted for rotation about a gate axis, and

[0015] FIG. 4 is a schematic side elevation of another gate device of the second embodiment fixed from rotation about the gate axis.

[0016] Corresponding reference characters indicate corresponding parts throughout the several views of the drawings.

DETAILED DESCRIPTION OF THE PREFERRED EMBODIMENT

[0017] Referring now to the drawings and in particular to FIG. 1, an axial feed system of the present invention is designated in its entirety by the reference numeral 11. The axial feed system forms part of a processing machine generally designated by 13 (only the feed system of the machine is shown in detail). An example processing machine is a feminine pad processing machine manufactured by Keller Technology Corporation of Buffalo, N.Y., though other types of processing machines are contemplated. The axial feed system 11 is desirably adapted to continuously feed ribbon material 14 from a coil 15 to the processing machine 13. Generally, the system 11 includes an intake feed mechanism 17 for pulling the ribbon material 14 into the processing machine and a powered turntable generally designated 19 positioned upstream from the intake feed mechanism for supporting the coil 15.

[0018] In the illustrated embodiment, the coil 15 is one of three coils which together form a stock 21 of ribbon material 14. Desirably, the stock 21 of ribbon material 14 includes more than three coils, e.g., 10, 20 or more coils. Although the coils 15 may be joined in other ways without departing from the present invention, in one embodiment an outer end 23 of each coil 15 is suitably spliced to a central end 25 of the adjacent lower coil, e.g., using double-sided adhesive tape or other adhesive, so that the coils are connected together for continuous feed to the machine 13. Each coil 15 is formed of ribbon material 14, such as absorbent raw material used in making feminine care products, wound about a central axis 27 of the coil. The ribbon material 14 is sheared or "slit" from a wide roll (e.g., having a width of one meter or more) of absorbent raw material. Each of the resulting coils of one embodiment has a thickness 28 between about 20 mm and about 50 mm, desirably about 37 mm and a diameter 29 between about one and about two meters, e.g., 1.2 meters. The central axis 27 is generally perpendicular to a plane 30 of the coil which is generally midway between a top 30a and bottom 30b of the coil. It will be understood that the thickness 28 and diameter 29 of the coil 15 may vary without departing from the scope of the present invention. It is contemplated that the stock 21 may include a continuous supply of ribbon 14, rather than spliced coils 15. In other words, a long, continuous ribbon 14 could be wound to form several coils 15. It is further contemplated that single coils be mounted one at a time on the turntable 19, rather than a stack of coils 15.

[0019] Still referring to FIG. 1, the intake feed mechanism 17 includes driven upper and lower rolls 31, 32, respectively, for pulling the ribbon material 14 from the coils 15 into the machine. The rolls 31, 32 are generally parallel and spaced apart so that there is a gap 33 between the rolls. The ribbon material 14 is threaded around a portion of each roll 31, 32 so that, as viewed in FIG. 1, the ribbon material engages the right portion of the periphery of the lower roll and the opposite or left portion of the periphery of the upper roll. Thus, the ribbon material 14 forms an "S" shape. Note that the roll arrangement of this embodiment is commonly referred to as an "S-wrap". To pull the material 14, the lower roll 32 is turned counterclockwise and the upper roll 31 is turned clockwise, as viewed in FIG. 1. As will be appreciated by those skilled in the art, this arrangement may be changed, e.g., as shown in FIG. 2, without departing from the scope of the present invention. The rolls 31, 32 of the embodiment shown in FIG. 1 are driven by a motor 35 connected to the rolls by a transmission 36 formed from belts and pulleys. A controller 37 is connected to the motor 35 and is adapted to activate the motor to begin feeding ribbon material 14 into the processing machine 13. Together, the rolls 31, 32, motor 35, transmission 36 and controller 37 form a pulling means. Other pulling means known in the industry are contemplated within the scope of the invention, such as a driven nip (not shown but similar to the nips described hereinafter) wherein parallel rollers of the nip grip the material in a space between the rollers, and the rollers are rotated to force the ribbon material through the space. Additional suitable pulling means well known in the industry include "vacuum conveyors" or "vacuum rollers" (not shown). Upon being pulled through the driven rolls 31, 32, the ribbon material 14 may be fed through additional downstream components such as a conventional tensioner (not shown) and may also be pulled by a second pulling means, such as a vacuum roller (not shown). Downstream from the driven rolls 31, 32, the ribbon material 14 is typically cut to a usable length by a cutting mechanism (not shown). These downstream components are schematically represented by element 39 forming a portion of the processing machine 13.

[0020] In this embodiment, the intake feed mechanism 17 includes a series of turnbars (e.g., four turnbars 41-44) positioned upstream from the driven rolls 31, 32 and downstream from the coils 15 for controlling twists in the ribbon material 14 unwound from the coils. Each turnbar 41-44 is a cylinder fixed to structure (not shown) of the processing machine 13, or to structure adjacent the machine. Additionally, one or more of the turnbars 41-44 may be rotatably mounted, rather than fixed, on the structure to reduce drag on the ribbon material 14 so it is less likely to break. The ribbon material 14 is threaded through the turnbars 41-44 to isolate the processing machine from twists in the unwound ribbon material. The turnbars 41-44 serve to change the ribbon material feed direction and to inhibit the twists from proceeding further downstream. Generally, the turnbars 41-44 are suitably shaped and arranged so that twists in the ribbon material 14 do not pass the last turnbar and are thus isolated from the driven rolls 31, 32.

[0021] In one embodiment, the turnbars 41-44 are arranged so that the first turnbar 41 and third turnbar 43 form an upper row of turnbars, the second turnbar 42 and fourth turnbar 44 form a lower row of turnbars, and the feed direction changes about 180° at each of the first three turnbars 41-43 and changes about 90° at the fourth turnbar.

A desirable turnbar arrangement will vary depending on the characteristics of the ribbon material **14** (e.g., its stiffness and strength) and the feed rate, among other factors. Note that the feed mechanism **17** may include other twist controlling devices (e.g., nips or gates, described below) in combination with or instead of the turnbars **41-44**.

[0022] The intake feed mechanism **17** is an axial feed mechanism adapted to pull the ribbon material **14** from the coils **15** at an angle **47** having an axial component **45** extending parallel to, or coincident with, the axis **27** of the coil (generally, a twist-promoting direction). In other words, the material **14** is pulled at the angle **47** to the plane **30** of the coil **15** so that twisting of the unwound ribbon material is likely to occur. The angle **47** may be nearly perpendicular to the plane **30**. A minimum pulling angle (not shown) which promotes or causes twisting will vary according to the characteristics of ribbon material **14**, the feed rate and other factors, and the minimum angle may range from as little as 1° to as much as 30°, 40° or 50° degrees. Referring again to FIG. 1, in one embodiment the ribbon material **14** is threaded over the turnbars **41-44**, and is pulled in the direction of the first turnbar **41** of the feed mechanism **17**. The first turnbar **41** is positioned generally above the coils **15**. The ribbon material **14** is pulled from the coils **15** at the angle **47** relative to the plane **30** of the coil **15** and, therefore, the unwound material twists. Note that the ribbon material **14** is pulled beginning at the center end **25** of the coil **15**, but may also be pulled beginning at the outer end **23** of the coil.

[0023] The powered turntable **19** includes a generally circular platform **49** having a generally horizontal support surface **51**. The powered turntable **19** further includes a pulley **53** attached to the platform **49** and a motor **55** connected to the pulley by a drive belt **57** for rotating the turntable. In one embodiment, the motor **55** is adapted to rotate the coils **15** continuously at a substantially constant rotational speed, and is not adapted to rotate the coils at intervals or at a variable rotational speed while the ribbon **14** is being fed into the machine **13**. During unwinding, the coils **15** are continuously rotated generally about the central axis **27** of the coils at a rotational speed selected to maintain a number of twists in the unwound ribbon material **14** below a predetermined number. Desirably, the predetermined number of twists in the unwound ribbon material **14** is sufficiently low that the ribbon material is substantially untwisted along at least some portion of the intake feed mechanism **17**. Accordingly, the rotational speed is selected such that the number of twists in the unwound ribbon material **14** is maintained sufficiently low that the ribbon material is substantially untwisted when passing through a downstream portion of the intake feed mechanism **17**. In this embodiment, the ribbon material **14** is untwisted when it is received by the driven rolls **31, 32**, and desirably is untwisted upstream from the driven rolls, e.g., at the fourth turnbar **44** or the third turnbar **43**. The predetermined number of twists in the unwound material **14** will vary depending upon, among other factors, distance between the coil **15** and the intake feed mechanism **17**, the characteristics of the ribbon material, and the number and configuration of twist controlling devices, such as the turnbars **41-44**, of the intake feed mechanism. The rotational speed in revolutions per minute (generally, per unit time) is desirably less than a number of revolutions of ribbon material **14** unwound adjacent the center of the coil **15** during one minute and greater than a number of revolutions of ribbon material

unwound adjacent the outer periphery of the coil during one minute. As will be understood by those skilled in the art, for a constant linear feed rate, the number of turns pulled from the coil **15** decreases from the center of the coil to its periphery. In one embodiment, a suitable range of rotational speed is between about 700 and about 1100 revolutions per minute for a feed rate of about 1000 feet per minute. Although the rotational speed may be determined in revolutions per minute as described above, those skilled in the art will appreciate that the rotational speed may be determined using other units of time (e.g., revolutions per second) without departing from the scope of the present invention. Because the intake feed mechanism **17** pulls the ribbon material **14** at a substantially constant rate, and turntable speed is constant, the number of twists in the unwound ribbon varies as each coil **15** is consumed.

[0024] During operation of the machine **13**, the controller **37** causes the driven rolls **31, 32** to rotate and thereby pull ribbon material **14**. Simultaneously, or shortly thereafter, rotation of the powered turntable **19** is initiated. Rotation of the turntable **19** is continuous during rotation of the driven rolls **31, 32** until the stock **21** is consumed.

[0025] Referring to FIGS. 2-4, in a second embodiment the intake feed mechanism **17'** includes an upstream or first nip **61** (generally, twist control device), an intermediate or second nip **62** and a downstream or third nip **63** (generally, twist controlling devices or material orienting device) positioned upstream from the driven rolls **31, 32** so that there are substantially no twists in the ribbon material **14** received by the driven rolls. Each nip **61-63** provides a gate, generally designated **75**, having an opening **77** therethrough for receiving the ribbon material **14**. The gates **75** provided by the first and second nips **61, 62** are rotatable about a gate axis GA generally coincident with a center of the respective opening **77**. However, the gate **75** provided by the third nip **63** is fixed from rotation about its gate axis GA. In one embodiment, each gate **75** includes at least two parallel rollers **79** mounted for rotation about respective parallel roller axes **81** which extend transverse to the gate axis GA.

[0026] As illustrated in FIG. 3, the first and second nips **61, 62** include a bearing assembly generally designated by **65** having an outer ring **67** and an inner ring **69** rotatably mounted inside the outer ring. The bearing assembly **65** is suitably a conventional bearing having ball bearings (not shown) mounted in a raceway (not shown) between the inner and outer rings **69, 67**, respectively. Each outer ring **67** is fixed to structure **71** of the processing machine. The rollers **79** of the first and second nips are rotatably mounted on the inner ring **69**. Thus, the rollers **79** are rotatable together within the inner ring **69** about the gate axis GA and independently about their respective roller axes **81**.

[0027] Referring to FIG. 4, the third nip **63** includes a support member **73** fixed to the structure **71**. Although the illustrated support member **73** is ring-shaped, those skilled in the art will appreciate the support member may have other shapes without departing from the scope of the present invention. The gate **75** provided by the third nip **63** is not rotatable about its gate axis GA (FIG. 2). The rollers **79** of the fixed third nip **63** are mounted on the support member **73** for rotation about the roller axes **81** (axes are shown in FIG. 3) but do not rotate about the gate axis GA.

[0028] The rollers **79** at least partially define a height **82** of the opening **77**. A width **80** of the opening **77** is defined

by an inner diameter of the inner ring 69. In one embodiment, the rollers 79 may be mounted so as to be movable relative to one another so that the space between the rollers is adjustable to vary the height 82 of the opening. Such mounting may be accomplished by mounting the rollers 79 in slots 82a (FIG. 2) formed in the inner ring 69 and the ring-shaped member 73 and holding the rollers in position, for example, by a conventional spring tension mechanism within the rollers (not shown). The rollers 79 may also be fixed to the inner ring 69 and support member 73, as by welding. In one embodiment, the height 82 (FIG. 3) of the opening 77 is generally equal to a thickness of the ribbon material 14, but may also be less than or greater than the thickness of the ribbon material. It is contemplated that stationary turnbars be used instead of rollers 79.

[0029] Referring to FIG. 3, the rotatable nips 61, 62 may include an actuator, generally designated 83, operatively connected to the inner ring 69 of each nip for rotating the respective nip. The actuator 83 of one embodiment is a motor 84 which rotates a gear 85 positioned to engage pins 87 fixed to the inner ring 69 of the respective bearing assembly 65. Other actuators are contemplated. The controller 37 (FIG. 1) is operatively connected to the motor 84 of each actuator 83 and activates one or both motors to reduce the number of twists in the ribbon material 14 adjacent the nips 61, 62. The intake feed mechanism 17 may also include conventional sensors (not shown) electrically connected to the controller 37 for sensing the number of twists in the ribbon material 14 adjacent each gate 75. The controller 37 may be programmed to cause rotation of the nip at predetermined time intervals, or when there is a predetermined number of twists (e.g., 5 twists) adjacent the nip.

[0030] Referring to FIG. 2, in one embodiment the unwound ribbon material 14 extends through the nips 61-63, over a turnbar 90 and is pulled by driven rolls 31, 32. The gate axis GA of each gate 75 is generally parallel or coincident with the axis 27 of the coils 15 such that ribbon material 14 is pulled in a twist-promoting direction. As the ribbon material 14 is pulled through the nips 61-63, twists, e.g., clockwise twists, form in the unwound ribbon material upstream from the first nip 61. When a predetermined number of twists are formed, the first nip 61 will rotate, e.g., 180° in a clockwise direction, and thereby remove one 180° twist upstream from the nip but cause one 180° twist to be formed downstream from the nip (between the first and second nips 61, 62). Rotation may be caused either by the torsional force of the twists in the ribbon material 14, or by the actuator 83 in response to a signal from the controller 37. Likewise, after a sufficient number of twists is formed between the first and second nips 61, 62, the second nip will rotate to form a twist in the material 14 between the second nip and the third nip 63. After a period of time, the twists upstream from the first nip 61 may begin to form in a counterclockwise or opposite direction (e.g., when the nips 61-63 are used with the turntable 19), and, therefore, the nips will begin to rotate in the opposite direction. Desirably, the third nip 63 does not rotate about its gate axis GA so that twists are unlikely to pass therethrough. Therefore, the ribbon material 14 is substantially untwisted (or flat) when it is received by the driven rolls 31, 32.

[0031] The nips 61-63 of the second embodiment may be advantageously used in combination with the turnbars 41-44 and/or with the coils 15 mounted on the turntable 19 as described in the first embodiment. The nips 61-63 may also be used in combination with coils as described in our co-pending applications filed simultaneously herewith, both of which are entitled METHOD FOR AXIAL FEEDING OF RIBBON MATERIAL AND A STOCK OF RIBBON MATERIAL COILS FOR AXIAL FEEDING and which are incorporated herein by reference. In the co-pending applications, some coils in a stack of coils reverse the unwind direction of the preceding coil. Use of such a stack of coils, without use of the turntable 19 of the first embodiment, may likewise prove advantageous in that the twists which are formed between the nips will be removed due to the reversal of the twisting direction.

[0032] The invention provides a relatively inexpensive method and apparatus for controlling or reducing twisting in "axially fed" ribbon material 14. The powered turntable 19 is less expensive than those shown in the prior art in that is powered by a one-speed motor which turns at a constant speed. The nips 61-63 provide a relatively simple and inexpensive apparatus for preventing twists from entering portions of the machine 13 wherein twisting of the ribbon material would cause problems or stoppages in feeding. The nips 61-63 need not be powered or controlled, though such mechanisms could be included as described herein.

[0033] When introducing elements of the present invention or the preferred embodiment(s) thereof, the articles "a", "an", "the" and "said" are intended to mean that there are one or more of the elements. The terms "comprising", "including" and "having" are intended to be inclusive and mean that there may be additional elements other than the listed elements.

[0034] As various changes could be made in the above constructions without departing from the scope of the invention, it is intended that all matter contained in the above description or shown in the accompanying drawings shall be interpreted as illustrative and not in a limiting sense.

What is claimed is:

1. A method of controlling twisting in ribbon material fed from a coil of ribbon material into a processing machine, the coil having a central axis perpendicular to a plane of the coil, the method comprising:

pulling ribbon material from the coil in a twist-promoting direction, and

continuously rotating the coil during the pulling step at a rotational speed selected so that a number of twists in the unwound ribbon is maintained below a predetermined number.

2. A method as set forth in claim 1 wherein the pulling step includes isolating twists in the unwound ribbon material from the processing machine.

3. A method as set forth in claim 1 wherein the coil is rotated at a substantially constant rotational speed selected so that the ribbon is substantially untwisted at a downstream portion of an intake feed mechanism of the processing machine.

4. A method as set forth in claim 3 wherein the pulling step includes pulling the ribbon material at a substantially constant linear rate such that the number of twists in the unwound ribbon varies as the coil is consumed.

5. A method as set forth in claim 4 wherein the rotational speed is less than a number of revolutions of ribbon material unwound adjacent the center of the coil per unit of time and greater than a number of revolutions of ribbon material unwound adjacent the outer periphery of the unwound coil per unit of time.

6. A method as set forth in claim 1 wherein the direction in which the ribbon material is pulled from the coil extends generally parallel to the central axis of the coil.

7. A method as set forth in claim 1 wherein the coil is rotated about the central axis.

8. A method of controlling twisting in ribbon material fed from a coil of ribbon material into a processing machine, the coil having a central axis perpendicular to a plane of the coil, the method comprising:

pulling ribbon material from the coil in a twist-promoting direction, and

continuously rotating the coil during the pulling step at a rotational speed selected such that the number of twists in the unwound ribbon is maintained sufficiently low so that the material is substantially untwisted at a downstream portion of an intake feed mechanism of the processing machine.

9. A method as set forth in claim 8 wherein the pulling step includes isolating twists in the unwound ribbon material from the processing machine.

10. A method as set forth in claim 8 wherein the pulling step includes pulling the ribbon material at a substantially constant rate such that the number of twists in the unwound ribbon varies as the coil is consumed.

11. A method as set forth in claim 10 wherein the rotational speed is less than a number of revolutions of ribbon material unwound adjacent the center of the coil per unit of time and greater than a number of revolutions of ribbon material unwound adjacent the outer periphery of the unwound coil per unit of time.

12. A method as set forth in claim 8 wherein the direction in which the ribbon material is pulled from the coil extends generally parallel to the central axis of the coil.

13. A method as set forth in claim 8 wherein the coil is rotated about the central axis.

14. A feed system of a processing machine for continuously feeding a coil of ribbon material thereto, the coil having a central axis perpendicular to a plane of the coil, the system comprising:

an intake feed mechanism for pulling the ribbon material into the processing machine, the intake feed mechanism being adapted to pull the ribbon material from the coil in a twist-promoting direction, and

a powered turntable positioned upstream from the intake feed mechanism for supporting the coil, said turntable continuously turning while the intake feed mechanism pulls the ribbon material into the processing machine.

15. A feed system as set forth in claim 14 wherein the turntable turns the coil at a substantially constant rotational speed.

16. A feed system as set forth in claim 14 further comprising a plurality of coils of said ribbon material supported by the turntable, said plurality of coils being connected in series for continuous feed to the processing machine.

17. A feed system as set forth in claim 14 wherein the intake feed mechanism includes turnbars for isolating twists in the ribbon material from the processing machine.

18. A feed system as set forth in claim 17 wherein the turnbars are rotatable.

19. A feed system as set forth in claim 14 wherein the intake feed mechanism includes at least one nip for isolating twists in the ribbon material from the processing machine.

20. A feed system of a processing machine for continuously feeding ribbon material thereto, the system comprising:

a turntable,

a coil of said ribbon material mounted on the turntable, the coil having a central axis perpendicular to a plane of the coil,

means for pulling the ribbon material from the coil into the processing machine, the pulling means being adapted to pull the ribbon material from the coil in a twist-promoting direction, and

means for continuously rotating the turntable and coil to reduce twisting in ribbon material pulled from the coil.

21. A feed system as set forth in claim 20 wherein the rotating means is adapted to rotate the coil at a substantially constant rotational speed.

22. A feed system as set forth in claim 20 further comprising a plurality of coils of said ribbon material supported by the turntable, said plurality of the coils being connected in series for continuous feed to the processing machine.

23. A feed system as set forth in claim 20 further comprising turnbars mounted downstream from the turntable for inhibiting twists in the ribbon material from entering the processing machine.

24. A feed system as set forth in claim 23 wherein the turnbars are rotatable.

25. A feed system as set forth in claim 20 further comprising at least one nip mounted for inhibiting twists in the ribbon material from entering the processing machine.

26. A feed system as set forth in claim 20 in combination with the processing machine.

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